

Split

K

Work Order ID 160798-1

160798

Page 1

Thursday, May 04, 2017 10:55:49 AM

Split-1

Item ID: D412-630-034

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Start Date: 5/15/2017 Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 6/1/2017 Req'd Qty: 4.00 *4*

Customer:

Reference: SCHEDULED

Approvals: Process Plan:  Date: MAY 04 2017 Tooling:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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IIN D412-630	Rev O
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MAY 08 2017

100	Document Control	0.00
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100

DC

Doc.Control -USB or Paperwork

DOCUMENT CONTROL

Memo 0.00

Photocopy bluefile & create labels per PPP D412-630-034 CHG005

DAS
27
9-89

110	Small Fab	0.00
-----	-----------	------

110

Small Fab

Small Fab

Small Fab

Memo 1.64

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: 123777

COAT exposed HARDWARE WITH LPS PROCYON

A/R LPS PROCYON BATCH: 153690

JUN 01 2017

1X

17/06/01

DAS
36
9-89

B#157772 x1

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

Work Order ID 160798

Thursday, May 04, 2017 10:55:49 AM

160798

Page 2

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N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Start Date: 5/15/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/1/2017 Req'd Qty: 4.00

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Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.08				1			DAS 38 9-89 JUN 01 2017
130 *130* Packaging Packaging	Pick Kit Memo	0.00 0.00				4			DAS 28 9-89 MAY 10 2017
140 *140* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.12							DAS 27 9-89 JUN 01 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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160798

Page 3

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Reference: SCHEDULED

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Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Packaging	0.00							
150									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-630-034								
	Location: _____								
	PPP Rev: _____								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.40							
Quality Control									

Sold SmB
7/6/17

DAS
21
9-89 JUN 01 2017

DAS
21
9-89 JUN 01 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER :							
Misidentified ☐	☐	Past Due								

Picklist Print

Thursday, May 04, 2017 10:55:48 AM

Page 1

Work Order ID: 160798

160798

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Start Date: 5/15/2017

Required Date: 6/1/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-11-08 JLM
IPP rev B ecn1019, added D2807-041 EC verified by:DD
IPP rev :C 11.01.06 added route seq ID DD vef:EC IPP REV:D
13.06.07 PER CHG004 DD vef:JLM IPP REV:E 16.06.23 AS
PER IIN REV.O DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310C8 *AN310C8* Nut		Purchased	No			110	Each	23.0000	2	8		DAS 6 9-89	
				<u>Location</u>				<u>Loc Qty</u>					
				ST331				23					
				m135704				23					
AN3C21A *AN3C21A* Bolt		Purchased	No			110	Each	15.0000	1	4		DAS 6 9-89	
				<u>Location</u>				<u>Loc Qty</u>					
				ST348				15					
				M135671				15					
AN44C7A *AN44C7A* Eyebolt		Purchased	No			130	Each	8.0000	1	4		DAS 28 9-89	
				<u>Location</u>				<u>Loc Qty</u>					
				ST339				8					
				m135704				2					
				m136295				6					

DAS
27
9-89

X1

2
2

JUN 01 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

Page 2

Thursday, May 04, 2017 10:55:48 AM

Work Order ID: 160798

160798

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Start Date: 5/15/2017

Required Date: 6/1/2017

Start Qty: 4.00

Required Qty: 4.00

AN4C10A Purchased No 130 Each 27.0000 1 4

AN4C10A

BOLT

**

DAS
8
9-89

MAY 10 2017 28
9-89

Location

Loc Qty

Loc Code

ST345

27

M135671

7

M136044

20

AN4C15A Purchased No 130 Each 41.0000 2 8

AN4C15A

Bolt

**

DAS
8
9-89

MAY 10 2017 28
9-89

Location

Loc Qty

Loc Code

FG

10

120360

10

ST343

31

M135672

1

M136301

30

AN4C6A Purchased No 130 Each 268.0000 1 4

AN4C6A

Bolt

**

DAS
8
9-89

MAY 10 2017 28
9-89

Location

Loc Qty

Loc Code

FG

14

103344

4

121657

10

OVER002

150

m137026

100

m137333

50

ST345

104

m136318

104

Thursday, May 04, 2017 10:55:48 AM

Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
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Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

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Page 3

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160798

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Start Date: 5/15/2017

Required Date: 6/1/2017

Start Qty: 4.00

Required Qty: 4.00

AN5C15A

Purchased

No

130

Each

34.0000

2

8

AN5C15A

Bolt

**

DAS
6
9-89

MAY 10 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

over003

20

M136089

20

ST337

14

M135442

14

8

DAS
6
9-89

MAY 10 2017

AN8C16

Purchased

No

110

Each

9.0000

2

8

AN8C16

Bolt

**

Location

Loc Qty

Loc Code

ST332

9

M136659

9

8

DAS
6
9-89

MAY 10 2017

D2012-107

Manufactured

No

110

Each

11.0000

1

4

D2012-107

Clevis

**

Location

Loc Qty

Loc Code

ST001

1

157180

1

WA004

10

156167

10

4

DAS
6
9-89

MAY 10 2017

D2803-042

Manufactured

No

110

Each

12.0000

1

4

D2803-042

Bracket Assembly

**

Location

Loc Qty

Loc Code

ST473

12

148431

12

4

Thursday, May 04, 2017 10:55:48 AM

Shop Packet Print

Page 3

DQA: _____ Date: _____



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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					

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Parent Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Start Date: 5/15/2017

Required Date: 6/1/2017

Start Qty: 4.00

Required Qty: 4.00

D2804-042

Manufactured No

110

Each

8.0000

1

4

D2804-042

RH Step Fwd Bracket

**

MAY 10 2017

Location

Loc Qty

Loc Code

ST475

8

148424

5

151323

2

158144

1

D2806-1

Manufactured No

130

Each

19.0000

2

8

D2806-1

Bushing

**

MAY 10 2017

Location

Loc Qty

Loc Code

ST011

19

155224

19

D2806-3

Manufactured No

130

Each

21.0000

2

8

D2806-3

Bushing

**

MAY 10 2017

Location

Loc Qty

Loc Code

ST011

21

155388

21

D2807-041

Manufactured No

110

Each

14.0000

2

8

D2807-041

Prop Assembly

**

MAY 10 2017

Location

Loc Qty

Loc Code

FG

2

89606

2

ST011

12

157058

12

Thursday, May 04, 2017 10:55:48 AM

Shop Packet Print

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Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 160798

160798

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Start Date: 5/15/2017

Required Date: 6/1/2017

Start Qty: 4.00

Required Qty: 4.00

D2810-5 Manufactured No 130 Each 11.0000 1 4

D2810-5

Strut

MAY 10 2017

DAS
28
9-89

Location	Loc Qty	Loc Code
ST377	11	
134899	1	
142838	4	
153763	6	

DAS
27
9-89

D2813 Manufactured No 110 Each 11.0000 2 8

D2813

Washer

MAY 10 2017

Location	Loc Qty	Loc Code
ST011	11	
149366	11	

D3395-1 Manufactured No 110 Each 72.0000 4 16

D3395-1

Bushing

MAY 10 2017

Location	Loc Qty	Loc Code
ST033	72	
149467	72	

D3396-1 Manufactured No 130 Each 14.0000 2 8

D3396-1

Spacer

MAY 10 2017

Location	Loc Qty	Loc Code
ST033	14	
149446	14	

DAS
27
9-89

D3562-042 Manufactured No 110 Each 0.0000 1 4

D3562-042

Step Weldment

17/06/01

DAS
36
9-89

3157772 (1x)

Thursday, May 04, 2017 10:55:49 AM

Shop Packet Print

Page 5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

Thursday, May 04, 2017 10:55:49 AM

Work Order ID: 160798

160798

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Start Date: 5/15/2017

Required Date: 6/1/2017

Start Qty: 4.00

Required Qty: 4.00

D3672-15 Manufactured No 110 Each 134.0000 5 20

D3672-15

Phenolic Washer

**

MAY 10 2017

Location

Loc Qty

Loc Code

ST047

134

151784

134

20

D3672-17 Manufactured No 130 Each 231.0000 7 28

D3672-17

Phenolic Washer

**

MAY 10 2017

Location

Loc Qty

Loc Code

ST047

231

148074

7

150866

224

7

21

D3672-19 Manufactured No 110 Each 168.0000 4 16

D3672-19

Phenolic Washer

**

MAY 10 2017

Location

Loc Qty

Loc Code

ST050

168

148075

168

16

D3672-5 Manufactured No 130 Each 675.0000 7 28

D3672-5

Washer, Phenolic

**

MAY 10 2017

Location

Loc Qty

Loc Code

FG

8

44679

8

ST047

167

50354

167

ST051A

500

153354

500

28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 160798

160798

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Start Date: 5/15/2017

Required Date: 6/1/2017

Start Qty: 4.00

Required Qty: 4.00

D3672-7

Manufactured No

110

Each

843.0000

4

16

D3672-7

Washer, Phenolic

MAY 10 2017

Location

Loc Qty

Loc Code

FG

21

129987

6

133986

15

ST047

322

153039

322

ST051A

500

157442

500

16

MS21043-3

Purchased

No

110

Each

524.0000

4

16

MS21043-3

Nut

MAY 10 2017

Location

Loc Qty

Loc Code

FG

80

103691

80

FP001

176

m130673

11

m136182

165

GA

199

m133990

27

m136182

172

ST304

69

m131340

69

DAS
6
2-89

16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Picklist Print

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Work Order ID: 160798

160798

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Start Date: 5/15/2017

Required Date: 6/1/2017

Start Qty: 4.00

Required Qty: 4.00

MS21043-4

Purchased

No

130

Each

930.0000

4

16

MS21043-4

Nut

Location

Loc Qty

Loc Code

FG	40	
104603	40	
GA	7	
m132803	7	
ST302	883	
m136406	2	
m136983	281	
m137361	300	
m137371	300	

MAY 10 2017

DAS
28
9-89

DAS
27
9-89

MS21043-5

Purchased

No

130

Each

187.0000

3

12

MS21043-5

Nut

Location

Loc Qty

Loc Code

FG	20	
101418	20	
GA	71	
116548	71	
ST302	96	
m137361	96	

MAY 10 2017

DAS
28
9-89

DAS
27
9-89

MS24665-302

Purchased

No

110

Each

69.0000

2

8

MS24665-302

Cotter Pin

Location

Loc Qty

Loc Code

ST288	69	
m135672	69	

MAY 10 2017

DAS
28
9-89

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Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____				MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐ _____							

Picklist Print

Thursday, May 04, 2017 10:55:49 AM

Work Order ID: 160798

160798

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Folding Heli-Access-Step™ RH - Low, High & Float Gear

Start Date: 5/15/2017

Required Date: 6/1/2017

Start Qty: 4.00

Required Qty: 4.00

MS24693-C280

Purchased

No

110

Each

8.0000

2

8

MS24693-C280

SCREW

Location

Loc Qty

Loc Code

ST287

8

m135672

8

MS24693-C285

Purchased

No

110

Each

25.0000

1

4

MS24693-C285

Screw

Location

Loc Qty

Loc Code

ST287

25

m135704

25

MAY 10 2017

MAY 10 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					



Transport Canada

Transports Canada

Department of Transport

Supplemental Type Certificate

This approval is issued to:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario
Canada K6A 1K7

Number: SH96-69**Issue No.:** 7**Approval Date:** May 29, 1996**Issue Date:** December 22, 2005**Responsible Office:**

Ontario

Aircraft/Engine Type or Model:

BELL 205A, 205A-1, 205B, 212, 214B, 214B-1, 412, 412 CF,
412 EP

Canadian Type Certificate or Equivalent:

BELL 205A, 205A-1 H1SW
BELL 205B H-104
BELL 214B, 214B-1 H-80
BELL 212, 412, 412 CF, 412 EP H-86

Description of Type Design Change:

Heli-Access-Step

**Installation/Operating Data,
Required Equipment and Limitations:**

Manufacture of the Heli-Access-Step must be done in accordance with Dart Aerospace Ltd. Master Document List, MDL-412-630, Revision B, approved Dec 15, 2005, or later approved revisions.

Installation of the Heli-Access-Step must be done in accordance with Dart Aerospace Ltd. Installation Instruction D412-630, Revision J, approved Dec 08, 2005, or later approved revisions.

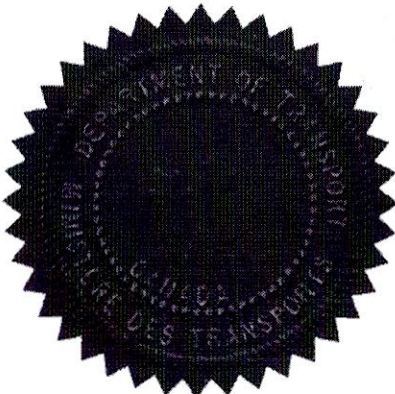
Maintenance of the Heli-Access-Step must be done in accordance with Dart Aerospace Ltd. Instructions for Continued Airworthiness, ICA-D412-630, Revision 1, Transport Canada accepted Dec 22 2005, or later Transport Canada accepted revisions.

Operations with the Heli-Access-Step installed must be in accordance with Dart Aerospace Ltd. Flight Manual Supplement FMS-D412-630, Revision D, Transport Canada approved Dec 22 2005, or later Transport Canada approved revisions.

Basis of Certification:

The basis of certification for this modification was FAR 29, up to and including Amendment 29-47

-- End --



Conditions: This approval is only applicable to the type/model of aeronautical product specified therein. Prior to incorporating this modification, the installer shall establish that the interrelationship between this change and any other modification(s) incorporated will not adversely affect the airworthiness of the modified product.


M.G. Mariotti
For Minister of Transport

Canada

Work Order ID 160/98

Thursday, May 04, 2017 10:55:49 AM

160/98

Item ID:	D412-630-034	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:					Stop	*NS2*
Item Name:	Folding Heli-Access-Step™ RH - Low, High & Float Gear					
Start Date:	5/15/2017	Start Qty:	4.00	*4*	Cust Item ID:	
Required Date:	6/1/2017	Req'd Qty:	4.00	*4*	Customer:	
Reference:	SCHEDULED					
Approvals:	Process Plan:	Date:	MAY 04 2017	Tooling:	Date:	
	QC:	Date:		SPC (Y/N):	Date:	
					Run	Start *NR1*
					Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-630	Rev O								
100	Document Control .	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & create labels per PPP D412-630-034 CHG005								
110		0.00							
110	Small Fab								
Small Fab	Memo	1.64							
Small Fab	Assemble as per dwg D412-630 p.14								
	Coat all hardware with LPS3 rust inhibitor								
	A/R LPS3 batch:								
	COAT exposed HARDWARE WITH LPS PROCYON .								
	A/R LPS PROCYON BATCH:								

CB - (H) MAY 08 2017

REFERENCE ONLY

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
7	7			D3672-5	WASHER (OR NAS1515H5)
		4	4	D3672-7	WASHER (OR NAS1515H5L)
		5	5	D3672-15	WASHER (OR NAS1515H3)
7	7			D3672-17	WASHER (OR NAS1515H4)
		4	4	D3672-19	WASHER (OR NAS1515H8)
		1	1	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C65)
		1	1	MS24693-C285	SCREW (OR MS24694-C76)